

Work Order ID 148309

Tuesday, June 28, 2016 9:03:00 AM

148309

Page 1

Item ID: D2022-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 6/24/2016 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 6/27/2016 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: **JUL 05 2016** SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2022	B

100 0.00

100

Hardinge Memo 0.13

Hardinge CNC Lathe Small

Note: .257" dia drill
 1-Turn as per folio FA206 & dwg
 FOLIO REV: 49
 DWG REV: B

2-Deburr as required

40 0

DAS
49
9-89

16/09/06

110 0.00

110

QC Memo 0.07

Quality Control

40 0

DAS
49
9-89

16/09/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

148309

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

40

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

120

QC

Memo

0.13

Quality Control

0.00

130

Packaging

Memo

0.07

Packaging

0.00

140

QC

Memo

0.67

Quality Control

DAS
21
DAS
21
9-89

SEP 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, June 28, 2016 9:03:00 AM

Page 1

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148309

Parent Item: D2022-101

D2022-101

Parent Item Name: Spacer

Start Date: 6/24/2016

Required Date: 6/27/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP D02.03.07 Now made in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	36.1465	0.03	1.2			

M6061T6R0 750

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

36.1465

m131999

1.2705

m133560

2.069

m134158

8.957

m134551

11.85

m135094

12



1.09

DAS
49
9-89

16/09/06

DQA: _____ Date: _____

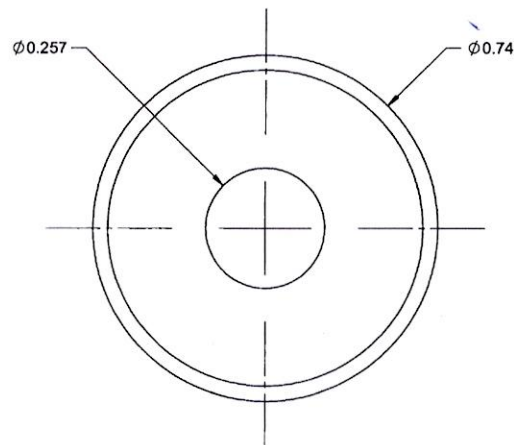
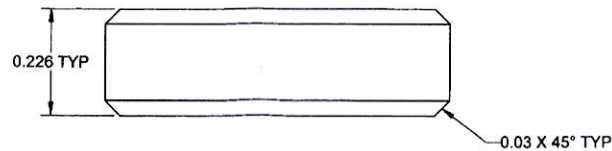


WORK ORDER NON-CONFORMANCE / UPDATE

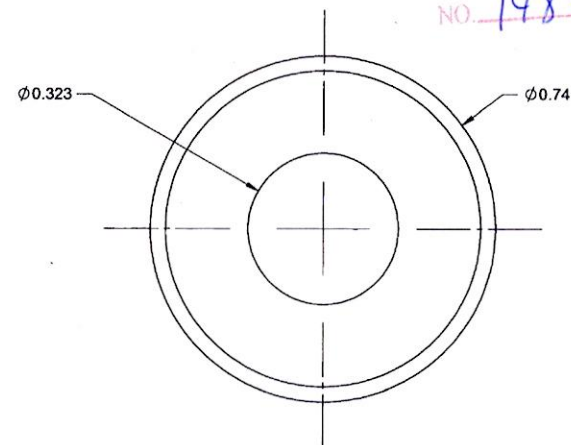
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Work Order update only ☐

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OTHER : ☐																									



D2022-101 SPACER



D2022-103 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148309 M5
1607-05

RELEASED
2014-08-27

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T62 ALUMINUM ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 (REF DART SPEC M6061T6R0.750)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2022-101" OR "D2022-103" PER QSI 044 6.7
- 7) WEIGHT: 0.01 lbs

B	RE-FORMAT DRAWING	DB	14.03.12
A	NEW ISSUE	JB	90.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D2022	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPACER	NTS
DATE	14.03.12	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OUTSIDE OF COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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